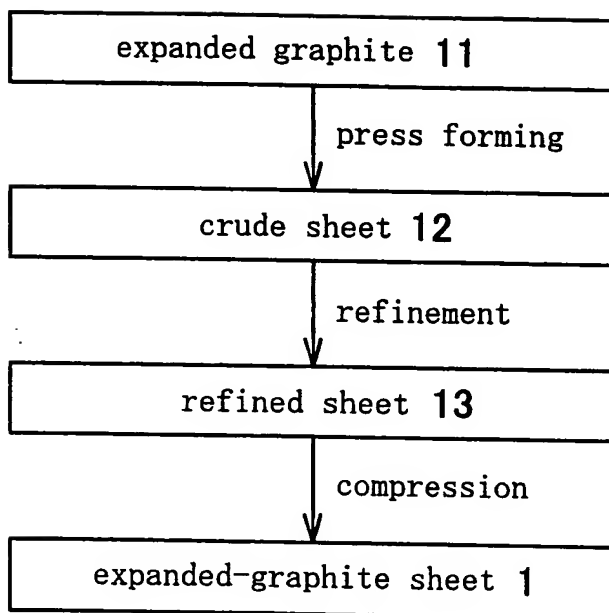




REPLACEMENT SHEET

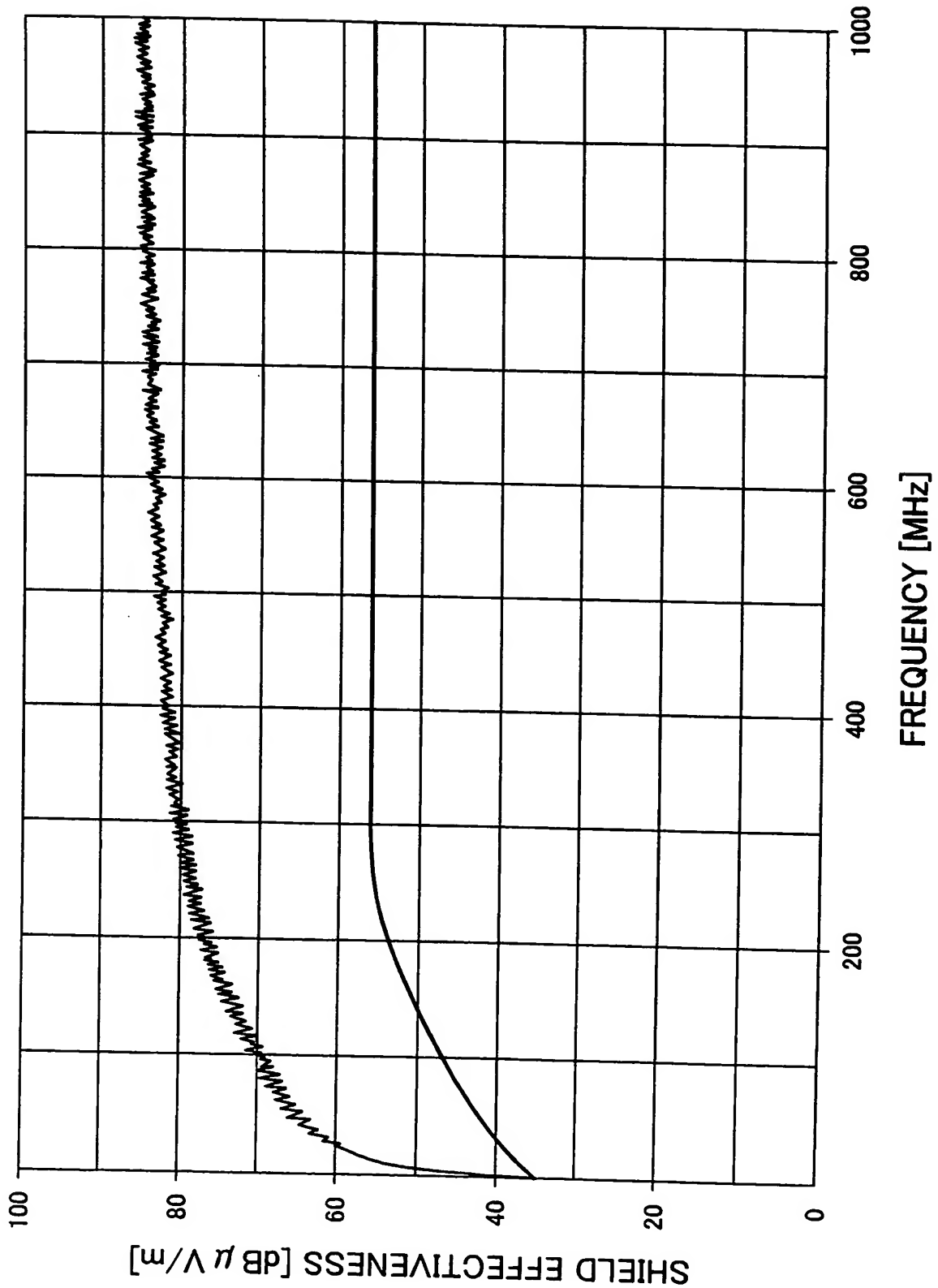
1/3
F I G. 1





REPLACEMENT SHEET

2/3
F I G. 2





REPLACEMENT SHEET

3/3
F I G. 3

| | rolling speed (m/min) | | | | | |
|--|-----------------------|------------|---------|---------|---------|---------|
| | 1 | 2 | 4 | 6 | 8 | 10 |
| | no creases | no creases | creases | creases | creases | creases |
| creases | | | | | | |
| surface roughness center line average height Ra (μm) | 2 | 3 | 5 | 6 | 6 | 6 |
| $\frac{\text{Max-Min}}{\text{Ave}} \times 100 (\%)$ | 5 | 8 | 14 | 14 | 22 | 30 |